In the Abstract:

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Abstract

~~A stator of an electric machine, which stator has an annular stator core (13) comprised of at least one stator core segment (14), having a welding seam (20) that joins the at least one stator core segment (14). In the stator, the welding seam depth (T_S) of the welding seam is a function of a yoke height (H_{yoke}) and a tolerance value (ΔT_S) and is described by the function~~
~~$T_S = 0.5mm * (H_{yoke}/mm - 1) \pm \Delta T_S$.~~
~~(Fig. 2)~~
The method for making a stator includes making individual strip-shaped laminas (15) for it; stacking the laminas (15) to form a stator core (13) with grooves (18) on one side extending through the core; producing a subassembly by inserting a stator winding (17) into the grooves (18); bending the subassembly to form a cylindrical cavity so that the grooves (18) end in the cavity and connecting two ends (23) of the stator core (13) to each other by a welding seam (20) to maintain this configuration. To produce a welding seam of sufficient strength which does not exert excessive influence on magnetic properties, the welding seam depth (T_S) is given by $T_S = 0.5$ mm $* (H_{yoke}/mm - 1) \pm \Delta T_S$, wherein H_{yoke} is yoke height and ΔT_S is a tolerance value. An electric machine including the stator made by this method is also described.

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